Accept	<b>Work Orde</b> November-21-13				*109	9523*						Page 1
Required Date: 11/21/13   Req'd Qty: 4.00   *4*   Customer:	Revision ID:		ır		Accept	*N900	<u>040</u>	100	<b>)*</b> s		171.	S1* S2*
Approvals: Process Plan: \( \text{\Date} : \) \( \t	Required Date:		- <del>•</del>				ID:					
Sequence ID/ Work Center ID Description Set Up/ Run Hours  Set Up/ Run Hours  Tool ID Tool # Plan Accept Reject Reject Insp.  Code Qty Qty Number Stamp  Draw Nbr Revision Nbr  D3608 C  100 **100* **100* **Memo 1-Cut as per Dwg D3608 Dwg Rev: C Prog Rev: C 2-Deburr if necessary  QC2- Inspect parts off machine FAI/FAIB  O.00  **110*  QC2- Inspect parts off machine FAI/FAIB  O.00  **110*		Process Pla	in: <u>µ</u> L5	Date: \3~\\-	LZ Tooling:	D	ate:		R		171	R1*
Work Center ID  Description  Run Hours  Code Qty Qty, Number Stamp  Praw Nbr Revision Nbr  D3608  C  1000  *1000		QC:		Date:	SPC (Y/N):	D	ate:				, *M	R2*
D3608   C		D	-			Tool ID	Tool #			•		
*100 * FLOW WATER JET  Waterjet Memo 0.00  FLOW CNC Waterjet 1-Cut as per Dwg D3608 Dwg Rev: C Prog Rev: C 2-Deburr if necessary  QC2- Inspect parts off machine FAI/FAIB 0.00  *110 * QC2- Inspect parts off machine FAI/FAIB 0.00	Draw Nbr	Rev	ision Nbr							<i>*</i> ·		
*100* Waterjet Memo 0.00  FLOW CNC Waterjet 1-Cut as per Dwg D3608 Dwg Rev: C Prog Rev: C 2-Deburr if necessary  QC2- Inspect parts off machine FAI/FAIB 0.00	9	C										
FLOW CNC Waterjet  1-Cut as per Dwg D3608 Dwg Rev: C Prog Rev: C 2-Deburr if necessary  QC2- Inspect parts off machine FAI/FAIB  0.00  *110*	*100*								4			A
*110* QC2- Inspect parts off machine FAI/FAIB 0.00		jet	1-Cut as pe Dwg Rev:_ Prog Rev:_	<u> </u>	0.00				•			14.01
			QC2- Inspect parts off r	nachine FAI/FAIB	0.00			•	1	λ.		1.
Quality Control	QC :		Memo		0.00					_0_		14.1

120

QC8- Inspect parts - second check

0.00

\*120\*

Memo Quality Control

0.00

@ 14-01-02

DAS 9 9-89

DQA:		<u>.</u>	Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF	PDATE					AEROSPACE
QA Closed:			Date:								W	ork Order up	date only		
Work Orde	ır.					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
Work Orde	.' -					Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap	i		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	•				_	Use-as-is	1	ļ.	noforming	Finishing			e/Packaging		Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update	1	Initial	Acti			Sign &			
Cause	$\dashv$	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	<u> </u>	QC Inspector
Design															
Doc/Data	_													Ì	
Equip/Tooling	$\dashv$								<u> </u>						
Handling/Pre	$\dashv$	!					١								
Material	_														
Operator Offset/Setup	$\dashv$											:			
Process							İ								
Supplier	$\dashv$														
Training					ļ										
Transport															
Unapproved															
							FA	ULT CA	TEGORY						
Landi	ng (	Gear				General		•		,		•	-		,
		Bending				Bend		Folio/F	Program		L	Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric	_	BOM/Route		Grain			_	Over/Under	tolerance		Set-up
	L	Cracks				Broken/Damage/Defect	<u>_</u>	Hardwa			<u> </u>	Part Incorre	<del>]-</del>		Temperature/Cure
	_	Crimp/Kir	nk/Ripple	/Wave		Burrs		- '	ion Incomplete/Un	•	L	Part Lost/Mi	ssing		Weld
	L	Cuffs				Contamination		4	tions Incomplete/L	Inclear	_	Part Moved	Ĺ		Wrong Stock Pulled
	<u> </u>	Crushing				Countersink	$\vdash$	-	gned/off center		<u> </u>	Positioned V			 
		Heat Trea				Cut Too Short	-	Mislab			L_	Power Loss/	Surge [		Other
		Inspectio		Tube		Drawing	<u> </u>	Misrea					<u></u>		
	_	Marks/Ch			<u> </u>	Drill Holes	<b> </b>	Off-set		,					
	_	Turning S			$\vdash$	Finish	$\vdash$	-	Calibration						
1	l	Wave/Tw	ist in Tub/	oe e		Fit/Function	1	Out of	Sequence						

\*109523\*

Page 2

November-21-13 2:33:51 PM

11010111001 21 1		·-								
Item ID:	D3608-3			Accept	*N900	040100	)* s	etup Sta	rt *NS	1 *
<b>Revision ID:</b>						.,—.,,.,,	•	<b>C</b> .		
Item Name:	Upper Doubl	er						Sto	<sup>p</sup> *NS:	<b>2</b> *
Start Date:	11/21/13	Start Qty: 4.00	*4*		Cust Item I	D:				
Required Date	: 11/21/13	<b>Req'd Qty:</b> 4.00	*4*		<b>Customer:</b>					
Reference:			<del></del>				_	~.		
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:	R	un Sta	"INK	1*
	QC:		Date:	SPC (Y/N):	<b>D</b> :	ate:		Sto	*NR	2*
Sequence ID/ Work Center	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty		sp. amp
150		Identify as per dwg & St	ock Location: <u>ST17</u> 5	0.00				510		
*150*							4×	28	14-01-2	1
Packaging		Memo		0.00				9-39		
Packaging										
										1
									٠.	,
160		QC21- Final Inspection	- Work Order Release	0.00					d (4-01-	1 , 1
*160*								^	U 14-01-	10
QC !		Memo		0.00						
Quality Control									_	

plubl-10

DQA:			Date:										$\mathbb{G}^{\mathbb{Z}}$	ART
QA Closed:			Date:			WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE	W	ork Order up	odate only	7	EROSPACE
						DISPOSITION			AGAINST	DE	PARTMENT,	/PROCESS	<u></u>	
Work Orde	r: -					<b>5</b>			Child to be a Connectivities	_	1	Water Jet	7:	arina 🗀
Part N	lo.					Rework Scrap			Skid-tube Crosstube Machining Small Fab		4	d. Eng. Coor.	-1	uality
NCR N	lo.					Use-as-is Suspected Unapproved		Thern	noforming Finishing Large Fab Composite		Rec/Stoi	re/Packaging Supplier		Other
Root	Ī				Desci	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC I	nspector
Design														
Doc/Data													İ	
Equip/Tooling														
Handling/Pre	$\sqcup$													
Material														
Operator														
Offset/Setup												ļ		
Process							l							
Supplier						-								
Training			1						•					
Transport														
Unapproved														
				,			FAI	ULT CA	TEGORY					
Landi	ng (	Gear				General		_		_	_	_	_	
		Bending				Bend		Folio/f	Program		Outside Dim	ensions	Pressure	/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	•		Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci	Tempera	ture/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	issing	Weld	
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong S	tock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong		
		Heat Trea	it			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other	
	Γ	Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tul	oe		Fit/Function		Out of	Sequence					

Page 1

November-21-13 2:33:51 PM

Work Order ID:

109523

Parent Item:

D3608-3

Parent Item Name:

Upper Doubler

**Start Date:** 11/21/13

Required Date: 11/21/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 07-03-26 JLM

IPP Rev:B 08-10-15 preliminary issue DD verified by:EC

IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC

IPP Rev:D 10.02.16 rev.B as IPP

per dwg DD verified by:EC IPP Rev:E 10.11.17 as per PC1 dwg DD verified by:EC

Rev:F 10.11.29 as per revC dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	459.9000	0.7392	_3_1124212	-	Ac	M.01.0
304/316 .040 Sheet				Location		Loc Oty	<u>Lo</u>	c Code				/	
				MAT020		459.90001				<u>.</u>			
				m12	5754	24.17001						7 1	0
				m12	6852	115.73			12	L852	<del></del>	3 it	
				m12	7454	320			. ,	<u> </u>			

DQA:			Date:			•							$\mathcal{A}_{\mathcal{A}}$	7
						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UPDATE			_	AEROSPAC	∐ ∶ <i>E</i>
QA Closed:			Date:							W	ork Order up	date only		
			· <u></u>			DISPOSITION			AGAIN	ST DE	PARTMENT	/PROCESS		
Work Orde	er: _						. 1			_	, 1	_	<del>.</del>	٦
						Rework			Skid-tube Crosstul	_		Water Jet	Engineering	4
Part N	۱o. <sub>-</sub>					Scrap			Machining Small Fa noforming Finishi		4	d. Eng. Coor. re/Packaging	Quality Other	┨╏
NCR 1	do					Use-as-is Suspected Unapproved		mem	Large Fab Composi		i Kec/Stoi	Supplier		┨╏
NCIN	٠٠.					Suspected Onapproved	1		Large Tab Composi	"	1	Supplie! [	i	د
Root					Desc	ription of work order update	ı	nitial	Action	***	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Design														
Doc/Data						<b>'</b>								
Equip/Tooling							1		ļ					
Handling/Pre														
Material														
Operator							l							
Offset/Setup							l							
Process									·					
Supplier	Н		ļ											
Training	Ш						Į							
Transport	Н		i				1							
Unapproved			1	l			FΔ	III T CΔ'	TEGORY		<u> </u>	L		
Landi	ng G	Sear				General	17	OLI CA	120011					
		Bending				Bend	Г	] Folio/F	Program		Outside Dim	ensions [	Pressure/Forced	
		Centre N	ot Concei	ntric		BOM/Route	H	Grain	6		Over/Under		Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred		Temperature/Cure	e
		Crimp/Ki	nk/Ripple	/Wave		Burrs		1	ion Incomplete/Unqualified		Part Lost/Mi	issing	Weld	
		Cuffs	• ••			Contamination		1 '	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulle	ed .
		Crushing				Countersink		4	gned/off center		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other	_
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Cl	hatter			Drill Holes		Off-set						
		Turning S	Sequence			Finish		Out of	Calibration					
		Wave/Tw	vist in Tul	эe		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	109523
Description: Upper Doubler	Part Number:	D3608-3
Inspection Dwg: D3608 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	,098	_		. 1	UKm os
1.82	+/-0.030	1.82			V	
0.50	+/-0.030	,50			V	
11.50	+/-0.030	11.50			T	UKM-06
7.950	+/-0.010	7.950	<b>—</b>		V	
1.325	+/-0.010	1,325	-		<b>✓</b>	
2.25	+/-0.030	2.25	-		<b>✓</b>	
8.50	+/-0.030	8,50			T	,
3.750	+/-0.010	3.750	_		<b>V</b>	
1.250	+/-0.010	1.250			V	
6.82	+/-0.030	6.82	_		V	
2.46	+/-0.030	2.46			V	
7.07	+/-0.030	7.07	_		V	
11.63	+/-0.030	11.63			T	
2.28	+/-0.030	2.28	_		V	
1.44	+/-0.030	1.44	. —		V	
8.56	+/-0.030	8.56	_		T	
2.00	+/-0.030	2.00	_		V	
0.040	+/-0.010	.035			V	

Measured by:	Audited by:	Preliminary Approval:
Date: 13.1	Date:	Date:
14.01.02		

Rev	Date	Change	Revised by	Approved
Α	09.05.11	New Issue	KJ	
В	10.02.18	Dimensions updated per Dwg Rev B	KJ ,	
С	10.12.21	Dimensions updated per Dwg Rev C	KJ St	18/



